



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5374-3

Job Sheet 180160



Part No: D5374-3

Job Qty: 80 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/29/18

Job Tracking No:

Due Date: 7/27/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 15-12-10 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	80 Ea		7/27/18	0.00	0.00	Start Up Machining-4		<i>18/07/26</i>
100	Hardinge	80 pcs		7/27/18	0.00	16.00	Hardinge		<i>18/07/26</i>
120	QC	80 pcs		7/27/18	0.00	0.00	QC8		<i>18/07/26</i>
130	Packaging	80 pcs		7/27/18	0.00	0.00	Packaging3-2		
140	QC21-SA	80 Ea		7/27/18	0.00	0.00	QC21		

Part Op
Descriptions: 100 - 1-TURN AS PER FOLIO FB445 & DWG D5374

Handwritten notes: AUG 01 2018, 21, 9-56

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.500	303 Round Bar 0.500"	14.6400 ft (.183 ea)	90-Start up Operation	<i>5082804</i>

Job Allocations

Operation	Component Part	Required	Inventory	Alloc.
90-Start up Operation	M303R0.500	15	83	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.500Inches + 0.006 - 0.001	0.506 0.499	Diameter	
2	Bushing	0.313Inches + 0.000 - 0.003	0.313 0.310	Diameter	
3	Bushing	30.000Degrees ± 0.500	30.500 29.500	Angle	
4	Bushing	0.035Inches + 0.030 - 0.010	0.065 0.025		
5	Bushing	2.050Inches + 0.000 - 0.005	2.050 2.045		
6	Bushing	0.020Inches ± 0.030	0.050 (0.010)	Radius	
7	Bushing	0.050Inches + 0.000 - 0.005	0.050 0.045		
8	Bushing	0.196Inches ± 0.005	0.201	Diameter	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

				0.191	
9	Bushing	0.226Inches	+ 0.010 - 1.000	0.236 (0.774)	
10	Bushing	90.000Degrees	± 0.500	90.500 89.500	Angle

Plex 6/29/18 9:50 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
Description Work Order Deviation		Disposition	Completed By
			Lead hand / Supervisor Approval Verification
			QC / QA Coordinator Approval

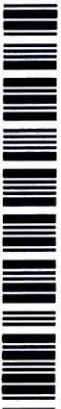
FAULT CATEGORY

Defect Complete/Unqualified	☐ Power Loss/Surge	☐ Positioned Wrong
	☐ Folio/Program	☐ Outside Dimensions
	☐ Grain	☐ Over/Under tolerance
	☐ Weld	☐ Part Incorrect
	☐ Wrong Stock Pulled	☐ Part Lost/Missing
	☐ Out of Sequence	☐ Part Moved
	☐ Off-set	☐ Drawing
	☐ Misabeled	☐ Finish
	☐ Fit/Function	☐ Misread
Complete/Unclear	☐ Misaligned/off center	☐ Turning Sequence

Dart Aerospace Ltd.
1270 Aberdeen Street
Newbury, ON K6A 1K7
CANADA
TEL: 513 832-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S096646



Part: D5374-3

Job No: 180160

Serial No/Batch: S096646

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/26/18